



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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SWA3-200
Job Sheet 189364



Part No: SWA3-200

Job Qty: 4 pcs

Part Name: Lower End



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/23/19

Job Tracking No:

Due Date: 2/22/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG SWA3-200 Rev 12 IPP Rev A 18.02.13 New issue DP verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	NLX 2500SY - 1	4 pcs	2/22/19	2/22/19	0.00	4.00	NLX 2500SY - 1		<i>[Signature]</i>
120	QC 2	4 pcs	2/22/19	2/22/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		<i>[Signature]</i>
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		



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CANADA
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Container No: S150858



Part: SWA3-200

Job No: 189364

Serial No/Batch: S150858

Revision: 12

Inspector:

Exp Date:

Instructions:

Date: 02/06/19

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130	QC 8	4 pcs	2/22/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	Am 19/02/12
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 38	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
140	Packaging 3-1 - Stock - B4B	4 pcs	2/22/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
150	QC 21 - SA	4 pcs	2/22/19	0.00 0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21

FEB 1 2019

Part Op 110 - NLX (MORI NLX 2500SY LATHE) 1-Machine as per DWG.FC301 FOLIO REV: _____ DWG REV: _____
Descriptions: _____ 2-Debur
120 - QC2- Inspect parts off machine FAI/FAIB)
130 - (QC8- Inspect parts - second check)
140 - (Identify as per dwg & Stock Location: _____)
150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R1.500	17-4 SS Round Bar 1.500"	1.4400 ft (.36 ea)	110-NLX 2500SY - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-NLX 2500SY - 1	M17-4-H1150-R1.500	1	21	0

Part Specifications

Specifications could not be found.

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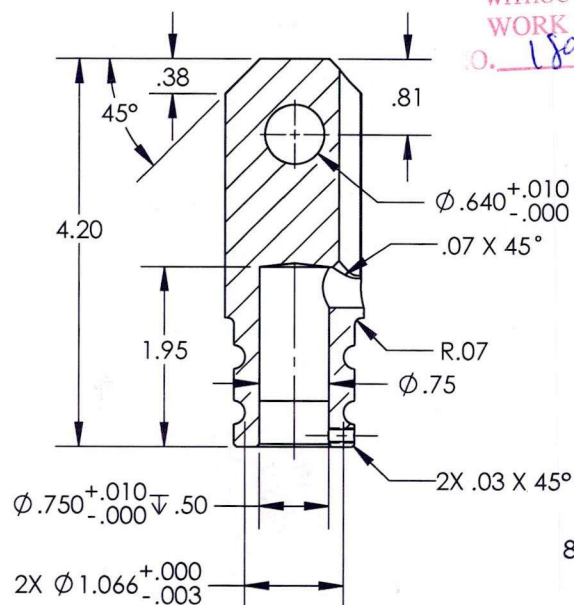


REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
7		AS DRAWN BY CANAM	8/24/2012		
8		ADDED MISSING .750 DIM, ADDED DEPTH .500 TO Ø.750	11/14/2012	JAG	
9		DELETED .02 X 45° FROM TOP, ADDED DRILL POINT DETAIL AND (1.99) DIM.	8/6/2013	RJC	GE
10	16-0084	REMOVED DIMS .981, .976, .381, .376. ADDED DIMS .420±.002, .425±.002, 1.020±.002, 1.025±.002. CH'D DIM WAS 1.75 IS 2X 1.75, WAS Ø1.066±.000/-003 IS 2X Ø1.066±.000/-003, WAS .750 IS .75±.00/-02. CH'D MATERIAL, WAS S.S. 17-4 PH, IS S.S. 17-4 H1150/H1075.	7/18/2016	SM	JAG
11	17-0027	CH'D DIM'S WAS .375 IS .38, WAS Ø.750 +.010/-000 Ψ.500 IS Ø.750 +.010/-000 Ψ.1.95, WAS R.069 IS R.07, WAS 2X .030 X 45° IS 2X .03 X 45°, WAS 2X 10-32 UNF -2B Ψ.500 IS 2X 10-32 UNF -2B Ψ.50, WAS 8-32 UNC -2B Ψ.328 IS 8-32 UNC -2B Ψ.33, WAS 4X R.015 IS 4X R.02. DELETED DIM'S 1.95, Ø.750. ADDED NOTE MACHINE ENGRAVE BATCH #.	2/1/2017	RJC	JAG
12	17-0146	CH'D DIM WAS Ø.750 +.010/-000 Ψ.1.95 IS Ø.750 +.010/-000 Ψ.50. DELETED DIM (1.99). ADDED DIM'S 1.95, Ø.75.	6/20/2017	RJC	JAG

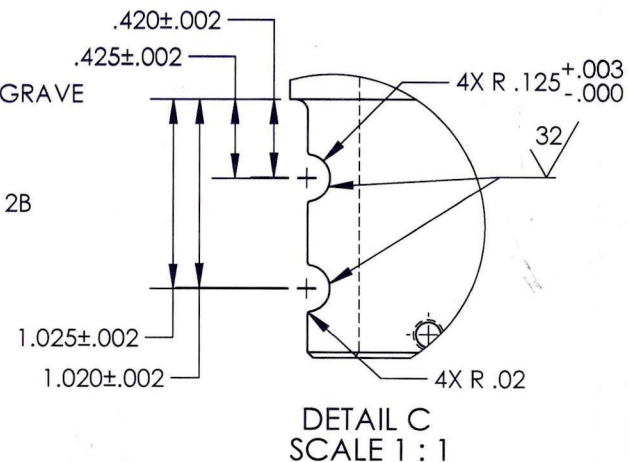
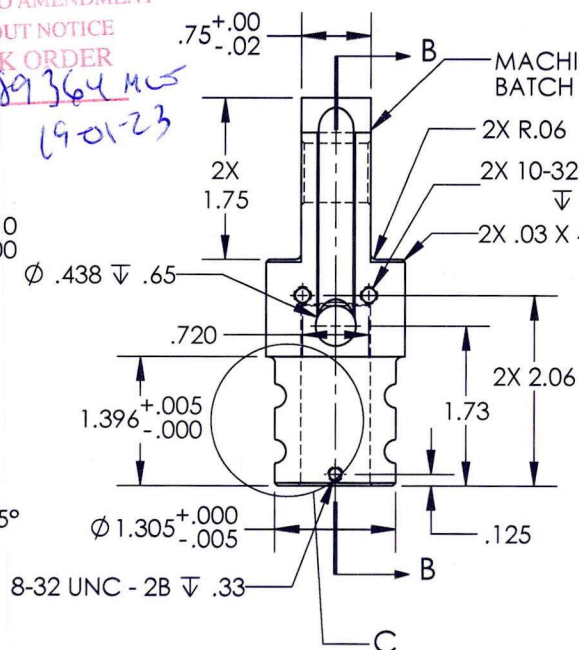
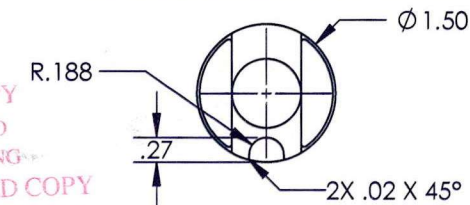
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

189364 MWS
190123



SECTION B-B



DART AEROSPACE	
TITLE LOWER END	
DWG NO. SWA3-200	REV 12
MAT'L S.S. 17-4, H1150/H1075 HEAT TREAT FINISH SPEC DRAWN BY: CANAM CHECKED: CLOUGH OPPTS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .008 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/ 1. BREAK ALL SHARP EDGES .015 X 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL	
SCALE 1:2	DATE 5/16/2006
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			SWA3-200	1	LOWER END	S.S. 17-4, H1150/H1075		

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order: 189364
Description: Lower END		Part Number: SWA3-200
Inspection Dwg: SWA3-200		Rev: 12
Page 1 of 1		

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.20	$\pm .01$	4.203			Vern LPO	
.38	$\pm .01$	.375				
45°	$\pm .5^\circ$	45°				
1.95	$\pm .01$	1.960				
Ø .750	$+ .01 / - .00$	.760				
Ø 1.066	$+ .000 / - .003$	1.0654			Opt Comp	
.03 x 45°	$\pm .01 \times .5^\circ$	.03 x 45°			Vern LPO	
Ø .75	$\pm .01$	.755				
R .07	$\pm .01$	.07			Rad gage	
Ø .640	$+ .01 / - .00$	.641			Mic LPO	
.81	$\pm .010$	.815			Mic LPO	
R .188	$\pm .005$	.1875			Rad gage	
.27	$\pm .01$	.268			HG	
Ø 1.50	$\pm .01$	1.490			Vern LPO	
.02 x 45°	$\pm .01 \times .5^\circ$	.02 x 45°				
.75	$+ .00 / - .02$	.740				
1.75	$\pm .01$	1.753				
Ø .438	$\pm .005$	.441				
.720	$\pm .005$	.722			HG	
1.396	$\pm .005 / - .000$	1.390			Vern LPO	
Ø 1.305	$+ .000 / - .005$	1.3025				
9-32 UNC-2B	G0 / NO G0	G0			G0-NO G0	
.125	$\pm .005$	.130			Vern LPO	
1.73	$\pm .01$	1.7275			HG	
2.06	$\pm .01$	2.064			HG	
.03 x 45°	$\pm .01 \times .5^\circ$	.03 x 45°			Vern LPO	
10-32 UNF-2B	G0 / NO G0	G0			G0-NO G0	
.50	$\pm .010$	.500			Vern LPO	

Measured by: 19-02-06	Checked by: amf	QC Inspector:
Date:	Date: 19/02/12	Date:

Engineering Approval: (if necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

